

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023920**Date Inspected:** 18-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yang ZPMC**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TA Yard OBG 13 / 14E**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A.DeArmond was present during the time noted above and conducted observations relative to the work being performed.

TRIAL ASSEMBLY**Ultrasonic Testing (UT)**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. All components were as listed on NWIT notification no. 09172. The member(s) is/are identified as 14BE Blockout Bottom Plate to Floor Beam. The weld designations reviewed are as follows

SEG3019AV-051 and SEG3019C-008

Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. All components were as listed on NWIT notification no. 09170. The member(s) is/are identified as 14BE Rib Stiffener to Floor Beam. The weld designations reviewed are as follows

SEG3019E-2-184, 188, 192, 196, 200, 204, 208, 212, 216, 217, 213, 209, 205, 201, 197, 193, 189, 185

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. All components were as listed on NWIT notification no. 09168. The member(s) is/are identified as 13AE Built-Up Saddle Support Beam. The weld designations reviewed are as follows

X3703-001-003, 004, 005, 006

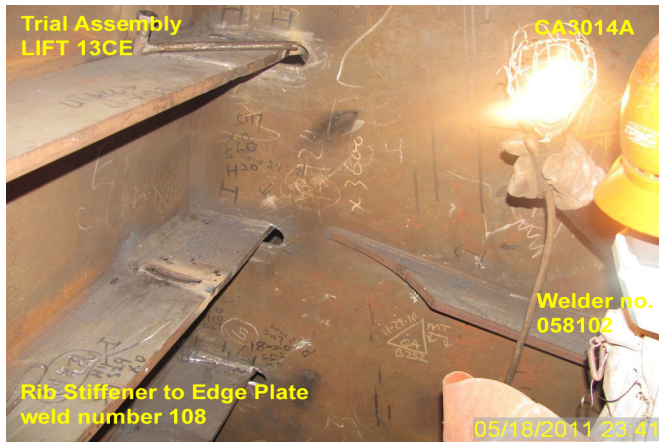
This QA Inspector observed the following work in progress:

FCAW welding of complete joint penetration weld joint(s) located on lift 13AE, OBE13AD Vertical Plate to Vertical Plate weld number(s) 001. Welder is identified as welder no. 050242. The welding variables recorded by ZPMC QC identified as Wang Xu appeared to comply with applicable WPS(s) WPS-B-T-2233-ESAB.

FCAW welding of complete joint penetration weld joint(s) located on lift 13BE, SA7009-001 Stiffener Splice Flange to Splice Plate weld number(s) 002, 003, 004. Welder is identified as welder no. 050977. The welding variables recorded by ZPMC QC identified as Wang Xu appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

FCAW welding of complete joint penetration weld joint(s) located on lift 13CE, CA3014A Rib Stiffener to Edge Plate weld number(s) 104 and 108. Welder is identified as welder no. 058102. The welding variables recorded by ZPMC QC identified as Wang Xu appeared to comply with applicable WPS(s) WPS-345-SMAW-4G (4F)-FCM-Repair and B-WR20542.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As mentioned above between QA and QC concerning this project

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Devy 150-002-6784, who represents the Office of Structural Materials for your

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

project.

Inspected By: DeArmond,Robert

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer